

Date: Friday, 15/02/2008 10:45:28 AM  
 User: Linda Lacelle

## Process Sheet

|   |   |
|---|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services                                   | <b>Drawing Name</b> : PLUG                                  |
| <b>Job Number</b> : 37474   |   |
| <b>Estimate Number</b> : 13093  |   |
| <b>P.O. Number</b> :  | <b>Part Number</b> : D3492053                               |
| <b>This Issue</b> : 15/02/2008 <b>S.O. No.</b> :  | <b>Drawing Number</b> : D3492 REV C                         |
| <b>Prsht Rev.</b> : NC  | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS                                   | <b>Drawing Revision</b> : C                                 |
| <b>Previous Run</b> : 37290   | <b>Material</b> :   |
| <b>Written By</b> : <u>J.F. 08.02.15.</u>   | <b>Due Date</b> : 22/02/2008 <b>Qty:</b> 10 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> :  |   |
| <b>Comment</b> : Est Rev:A New Issue 06-06-20 JLM<br>Est Rev:B as per Rev C 07-12-06 DD |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |              |                         |
|-----|--------------|-------------------------|
| 1.0 | M6061T6R0750 | 6061-T6 Round Bar .750" |
|-----|--------------|-------------------------|



**Comment:** Qty.: 0.0481 f(s)/Unit Total: 0.4809 f(s)  
 6061-T6 Round Bar .750"  
 (M6061T6R0750)  
 Batch: M103857

J.F. 08/02/15

(11)

Do NOT use Batch: B17790

|     |          |                          |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|

**Comment:** HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA715 & Dwg D3492  
 Dwg Rev: C  
 Folio Rev: AA

J.F. 08/02/15

(11)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/02/15

(11)

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

J.F. 08/02/15

(11)

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

J.F. 08/02/15

(11)

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 20/02/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Friday, 15/02/2008 10:45:28 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 37474

Part Number: D3492053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/02/19 (11)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Flat End Only)

FL 08/02/19 (13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-19 (X11)

9.0

NAS1611012

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-012 O-RING

M106043

FL

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch:

M101223

FL

08-02-19 (X11)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 08-02-19 (12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Finishing

FL

08-02-19

(X14)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/22

Job Completion

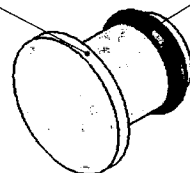


FL 2008/2/19

(H)

D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

| QTY<br>-041 | QTY<br>-043 | QTY<br>-045 | QTY<br>-047 | QTY<br>-049 | QTY<br>-051 | QTY<br>-053 | PART NUMBER | DESCRIPTION   |
|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|---------------|
| X           |             |             |             |             |             |             | D3492-041   | PLUG ASSEMBLY |
|             | X           |             |             |             |             |             | D3492-043   | PLUG ASSEMBLY |
|             |             | X           |             |             |             |             | D3492-045   | PLUG ASSEMBLY |
|             |             |             | X           |             |             |             | D3492-047   | PLUG ASSEMBLY |
|             |             |             |             | X           |             |             | D3492-049   | PLUG ASSEMBLY |
|             |             |             |             |             | X           |             | D3492-051   | PLUG ASSEMBLY |
|             |             |             |             |             |             | X           | D3492-053   | PLUG ASSEMBLY |
| 1           |             |             |             |             |             |             | D3492-1     | PLUG          |
|             | 1           |             |             |             |             |             | D3492-3     | PLUG          |
|             |             | 1           |             |             |             |             | D3492-5     | PLUG          |
|             |             |             | 1           |             |             |             | D3492-7     | PLUG          |
|             |             |             |             | 1           |             |             | D3492-9     | PLUG          |
|             |             |             |             |             | 1           |             | D3492-11    | PLUG          |
|             |             |             |             |             |             | 1           | D3492-13    | PLUG          |
|             |             | 1           |             |             |             |             | NAS1611-005 | O-RING        |
|             |             |             | 1           |             |             |             | NAS1611-007 | O-RING        |
| 1           |             |             |             |             |             |             | NAS1611-010 | O-RING        |
|             |             |             |             |             |             | 1           | NAS1611-012 | O-RING        |
|             | 1           |             |             |             |             |             | NAS1611-013 | O-RING        |
|             |             |             |             |             | 1           |             | NAS1611-015 | O-RING        |
|             |             |             |             | 1           |             |             | NAS1611-016 | O-RING        |



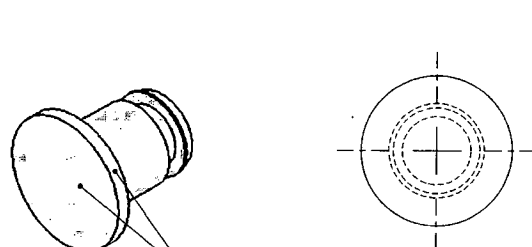
#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

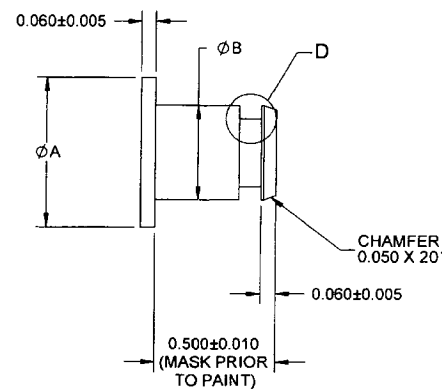
RELEASED  
07.10.05

|            |   |    |          |
|------------|---|----|----------|
| C          | ADD -049/-051/-053, CHANGE DRAWING FORMAT | PH | 07.10.05 |
| B          | ADD -047; UPDATE DIM A FOR -045           | PH | 05.05.11 |
| A          | NEW ISSUE                                 | PH | 06.01.04 |
| REV.       | DESCRIPTION                               | BY | DATE     |
| DESIGN     |   |    |          |
| DRAWN      |   |    |          |
| CHECKED    |   |    |          |
| MFG. APPR. |   |    |          |
| APPROVED   |   |    |          |
| DE APPR.   |   |    |          |
| DATE       | 07.10.05                                  |    |          |

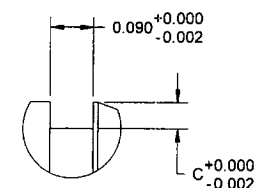
|  |                        |
|--|------------------------|
| <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |                        |
| DRAWING NO.<br><b>D3492</b>  | REV. C<br>SHEET 1 OF 2 |
| TITLE<br><b>PLUG</b>   | SCALE<br>2:1           |
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POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

| P/N      | A     | B     | C     | MATERIAL SPEC |
|----------|-------|-------|-------|---------------|
| D3492-1  | 0.625 | 0.394 | 0.055 | M6061T6R0.625 |
| D3492-3  | 0.750 | 0.582 | 0.045 | M6061T6R0.750 |
| D3492-5  | 0.375 | 0.188 | 0.045 | M6061T6R0.375 |
| D3492-7  | 0.500 | 0.270 | 0.045 | M6061T6R0.500 |
| D3492-9  | 0.938 | 0.750 | 0.045 | M6061T6R1.000 |
| D3492-11 | 0.850 | 0.664 | 0.045 | M6061T6R0.875 |
| D3492-13 | 0.750 | 0.520 | 0.045 | M6061T6R0.750 |

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

**RELEASED**  
07.11.16

|            |          |  |
|------------|----------|--|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA            |
| CHECKED    |          | DRAWING NO. <b>D3492</b>               |
| MFG. APPR. |          | REV. C                                 |
| APPROVED   |          | TITLE <b>PLUG</b>                      |
| DE APPR.   |          | SCALE 4:1                              |
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